

Work Order ID 50487



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July 10, 2009 2:37:08 PM

Item ID: D206-781-551KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Vertical Tunnel-Ivory

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 09-07-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D407-781

D-PROTO

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-781-551KIV CHG001

N/A

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Eng's test
PH 09.07.21

**ENGINEERING
APPROVAL**

BA 24-07-09

saved to PD

Rel 0303 A Juk

Work Order ID 50487

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Item ID: D206-781-551KIV

Accept

Revision ID: A-PROTO

Item Name: Vertical Tunnel-Ivory

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-781-551

Location: _____

PPP Rev: _____

09.07.21 Eng's testing

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

09.07.22 Prototype

change to w/o PD 03082011

Picklist Print

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Work Order ID: 50487

Parent Item: D206-781-551KIVRevA-PROTO

Parent Item Name: Vertical Tunnel-Ivory

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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ALS4-632-80		Purchased	No			110	Each	77.0000	2.0000			
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Insert

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	77	
17841	77	

AN525-10R14		Purchased	No			110	Each	100.0000	6.0000			
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Screw

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	100	
110023	100	

D3802-1RevB		Manufactured	No			110	f	55.0000	5.0000			
-------------	--	--------------	----	--	--	-----	---	---------	--------	--	--	--



Window Seal

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	55	
44630	5	
44916	50	

D3802-1-600

1 x 60" length of D3802-1

M17841 (2)

MF 09-07-24
05 M110023 (6X)
PICK / POUCH

NOT REQ'D
FOR TESTING
161
090721

Picklist Print

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Work Order ID: 50487

Parent Item: D206-781-551KIVRevA-PROTO

Parent Item Name: Vertical Tunnel-Ivory







Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3828-1KIVRevA- PROTO 		Manufactured	No			110	Each	0.0000	1.0000			
Vertical Tunnel Lower, LH												
D3828-2KIVRevA- PROTO 		Manufactured	No			110	Each	0.0000	1.0000			
Vertical Tunnel Lower, RH												
D3830-1KIVRevA- PROTO 		Manufactured	No			110	Each	0.0000	1.0000			
Vertical Tunnel Upper, LH												
D3830-2KIVRevA- PROTO 		Manufactured	No			110	Each	0.0000	1.0000			
Vertical Tunnel Upper, RH												
D3959-1KIVRevA- PROTO 		Manufactured	No			110	Each	0.0000	1.0000			
Vertical Tunnel, Aft Center												
D3970-1KIVRevA- PROTO 		Manufactured	No			110	Each	0.0000	1.0000			
Cover w/ Flashlight Holder												

B50480

B50481

B50482

B50483

B50484

B50485

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Work Order ID: 50487

Parent Item: D206-781-551KIVRevA-PROTO

Parent Item Name: Vertical Tunnel-Ivory

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-8		Purchased	No			110	Each	61.0000	12.0000			



RIVET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	61	
18744	61	

MS21059L3

Purchased

No

110

Each

871.0000

6.0000



Nut Plate

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	871	
109962	371	
111925	500	

NAS388-6-8P

Purchased

No

110

Each

61.0000

2.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	61	
111439	61	

118744 (120)

109962 (60)

111439 (20) 6/27/16

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Picklist Print

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Work Order ID: 50487

Parent Item: D206-781-551KIVRevA-PROTO

Parent Item Name: Vertical Tunnel-Ivory

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS391B6P		Purchased	No			110	Each	99.0000	2.0000			

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

99

110221

99

7/1/0221 28 10/1/16

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PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D206-781 / D407-781 (JOB # RD0303JUL)

Job #: _____

Date: 09.07.08

Product Name: Interior Trim Panels

Requested By: PH

Design Manager Approval: 

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3828-1KIV	thermo	Vertical Tunnel, Lower LH	09.06.12	Y	09.07.13	50480	
1	D3828-2KIV	thermo	Vertical Tunnel, Lower RH	09.06.12	Y	09.07.13	50481	
1	D3830-1KIV	thermo	Vertical Tunnel, Upper LH	09.06.12	Y	09.07.13	50482	
1	D3830-2KIV	thermo	Vertical Tunnel, Upper RH	09.06.12	Y	09.07.13	50483	
1	D3959-1KIV	thermo	Vertical Tunnel, Aft Center	09.06.17	Y	09.07.13	50484.	
1	D3970-1KIV	thermo	Cover w/ flashlight holder	09.06.30	Y	09.07.13	50485.	
1	D3802-1-600	purchase	? Seal	08.12.16	N	09.07.13		
1	D206-781-551 KIV sk		Vertical Tunnel Kit	09.05.27	N	09.07.13	Need Work Order 50487	

Not in system

	2	D3930-1	CLIP
	2	D3931-1	ANGLE
	4	MS35207-262	SCREW
	8	AN960C10L	WASHER
	8	MS21042L3	NUT
18	8	MS24694S50	SCREW

D206-781-511/-513 UTILITY KITS

Qty -511	Qty -513	Part Number	Description
X		D206-781-511	UTILITY KIT
	X	D206-781-513	UTILITY KIT W/ (ACS)
1		D206-781-541	CREW CABIN OVERHEAD
	1	D206-781-543	CREW CABIN OVERHEAD W/ DUCT
1	1	D206-781-551	VERTICAL TUNNEL KIT
1		D206-781-561	REAR OVERHEAD KIT
	1	D206-781-563	REAR OVERHEAD KIT (ACS)
1	1	D206-781-571	HAT BIN KIT

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.07.03 *PH*

D206-781-541/-543/-545/-551/-561/-563/-571 KITS

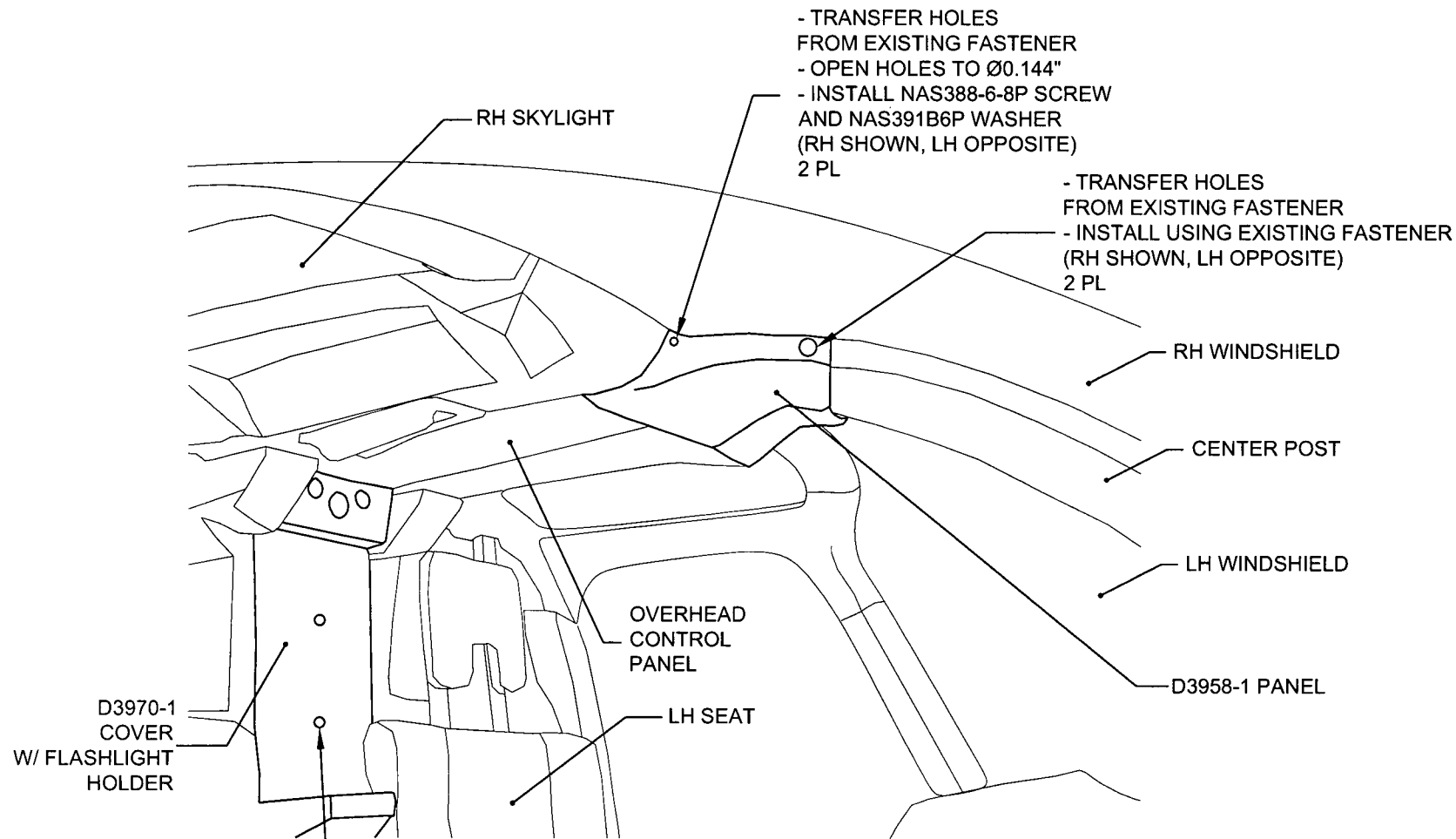
Qty -541	Qty -543	Qty -545	Qty -551	Qty -561	Qty -563	Qty -571	Part Number	Description
X							D206-781-541	CREW CABIN OVERHEAD
	X						D206-781-543	CREW CABIN OVERHEAD W/ DUCT
		X					D206-781-545	ROTOR BRAKE PANEL
			X				D206-781-551	VERTICAL TUNNEL KIT
				X			D206-781-561	REAR OVERHEAD KIT
					X		D206-781-563	REAR OVERHEAD KIT W/ DUCT
						X	D206-781-571	HAT BIN KIT
	1						D3844-041	OVERHEAD PANEL W/ DUCT, LH
	1						D3844-042	OVERHEAD PANEL W/ DUCT, RH
1							D3844-1	OVERHEAD PANEL, LH
1							D3844-2	OVERHEAD PANEL, RH
1	1						D3958-1	PANEL
		1					D3961-1	ROTOR BRAKE PANEL
6	6						NAS388-6-8P	SCREW
		4					NAS388-6-12P	SCREW
6	6	4					NAS391B6P	WASHER
2	2						NAS388-6-8P	SCREW
2	2						NAS391B6P	WASHER
		4					ALS4-632-80	INSERT
			1				D3828-1	VERTICAL TUNNEL, LOWER LH
			1				D3828-2	VERTICAL TUNNEL, LOWER RH
			1				D3830-1	VERTICAL TUNNEL, UPPER LH
			1				D3830-2	VERTICAL TUNNEL, UPPER RH
			1				D3959-041	VERTICAL TUNNEL, AFT CENTER
			1				D3970-1	COVER W/ FLASHLIGHT HOLDER
			1				D3802-1-600	SEAL
			2				NAS388-6-8P	SCREW
			6				AN525-10R16 <i>14</i>	SCREW
			2				NAS391B6P	WASHER
			6				MS21059L3	NUTPLATE
			12				MS20426AD3-8	RIVET
			2				ALS4-632-80	INSERT

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Revision: **D**

Date: 09.05.27

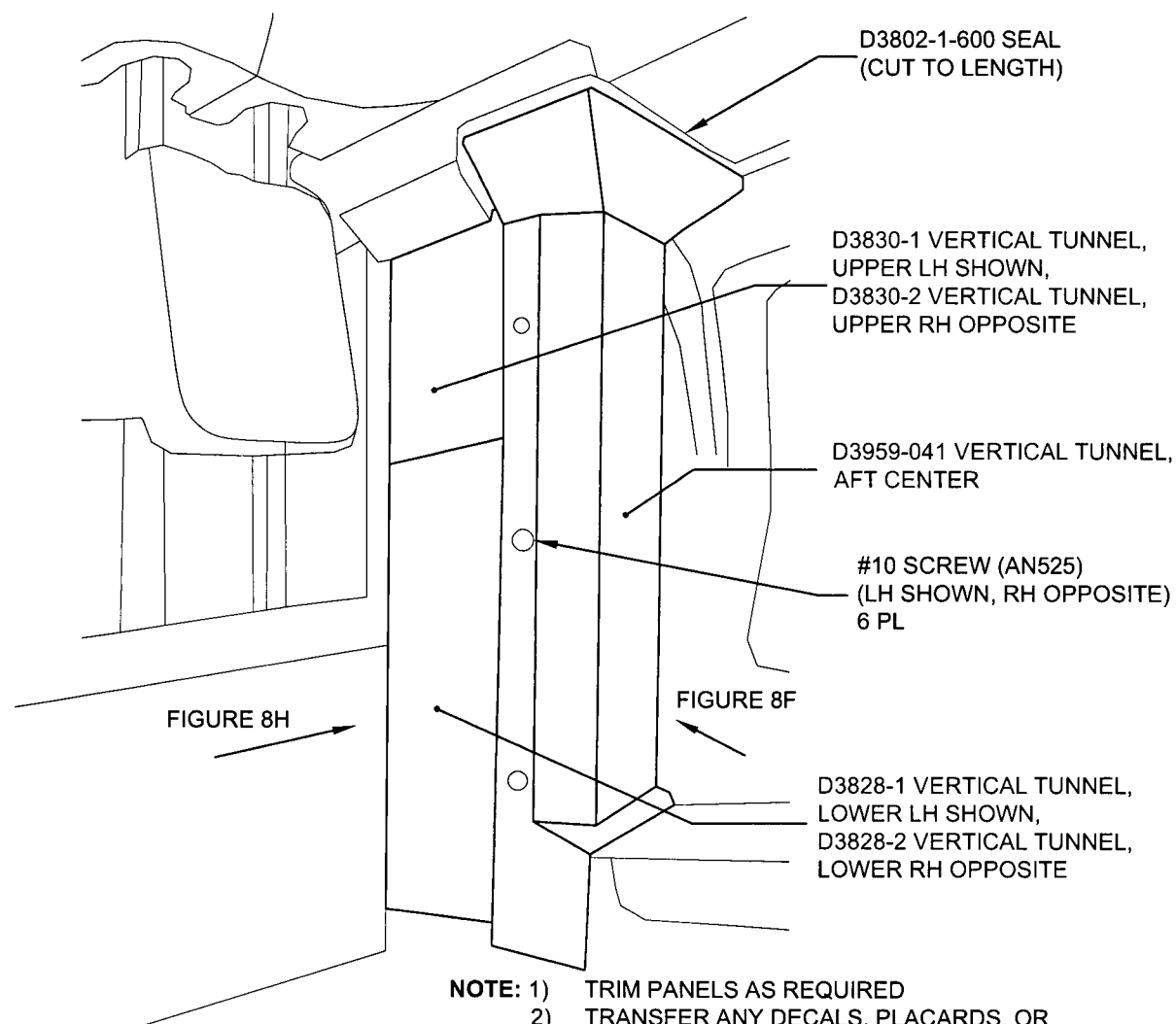


SUGGESTED LOCATIONS IF SUITABLE
HARDWARE/FASTENERS DO NOT EXIST

- DRILL Ø0.144" HOLES INTO AIRFRAME AND
TRANSFER TO PANEL
- OPEN HOLE IN AIRFRAME TO Ø0.266"
- INSTALL ALS4-632-80 INSERT INTO AIRFRAME
- INSTALL PANEL USING NAS388-6-8P SCREW
AND NAS391B6P WASHER
2 PL

- NOTE: 1)** IT IS ACCEPTABLE TO USE
LONGER/SHORTER AND LARGER DIAMETER OR
EXISTING FASTENERS AS REQUIRED
- 2)** TRIM PANELS AS REQUIRED
- 3)** TRANSFER ANY DECALS, PLACARDS, OR
STENCILED MARKINGS THAT ARE REQUIRED
FROM THE EXISTING PANELS

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09-07-07



- NOTE: 1) TRIM PANELS AS REQUIRED
2) TRANSFER ANY DECALS, PLACARDS, OR
STENCILED MARKINGS THAT ARE REQUIRED
FROM THE EXISTING PANELS

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09-07-00 *RL*